

Ship 12/06

Date: Thursday, 05/06/2008 10:28:58 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEBBING TIDY		
Job Number	: 39718			Part Number	: D32153		
Estimate Number	: 11381			Drawing Number	: D3215 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 05/06/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 12/06/2008		
Previous Run	: 35283			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est. A 04.01.06 New issue KJ/RF						
	Est Rev:B Now on Waterjet 06-07-03 JLM						
	est rev C ecn 940 07.06.12 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
Comment: Qty.: 0.0271 sf(s)/Unit Total : 0.2709 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify for D3215-3A Batch: <u>104981</u> <u>B 8-6-6</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3215 (D3215-3A) Dwg Rev: <u>P</u> <u>B 8-6-6</u> Prog Rev: <u>D</u>			
2-Deburr if necessary 3-Identify as D3215-3A			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<u>B 8-6-6</u>			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
<u>coantes</u> <u>S 0866666 429</u>			
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 10:28:58 AM
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 39718

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0084 sf(s)/Unit Total : 0.0840 sf(s)

5052-H32 .040 Sheet

Batch: M104921

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D3215-3B (2.130" x 0.530") as per dwg D3215

2-Deburr

3-Identify as D3215-3B

7.0	QC5	INSPECT WORK TO CURRENT STEP
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BS/06/06 29

✓ 08/06/06 429

Comment: INSPECT WORK TO CURRENT STEP

8.0	BRAKE NC	NC BRAKE
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SB 08/06/06 29

Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



✓ 08/06/06 29

Comment: INSPECT WORK TO CURRENT STEP

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M106834

✓ 08/06/06 29

Identify as D3215-3

Grind flush

SAP 08/06/06 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

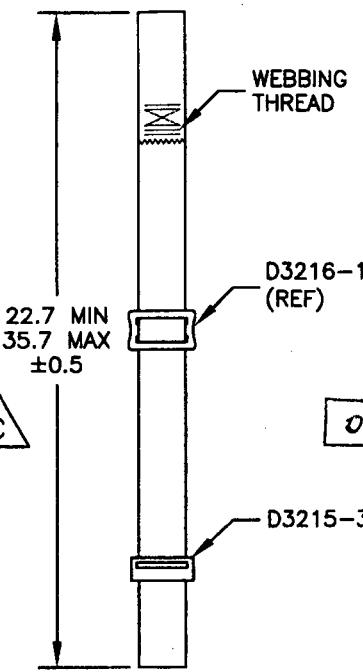
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

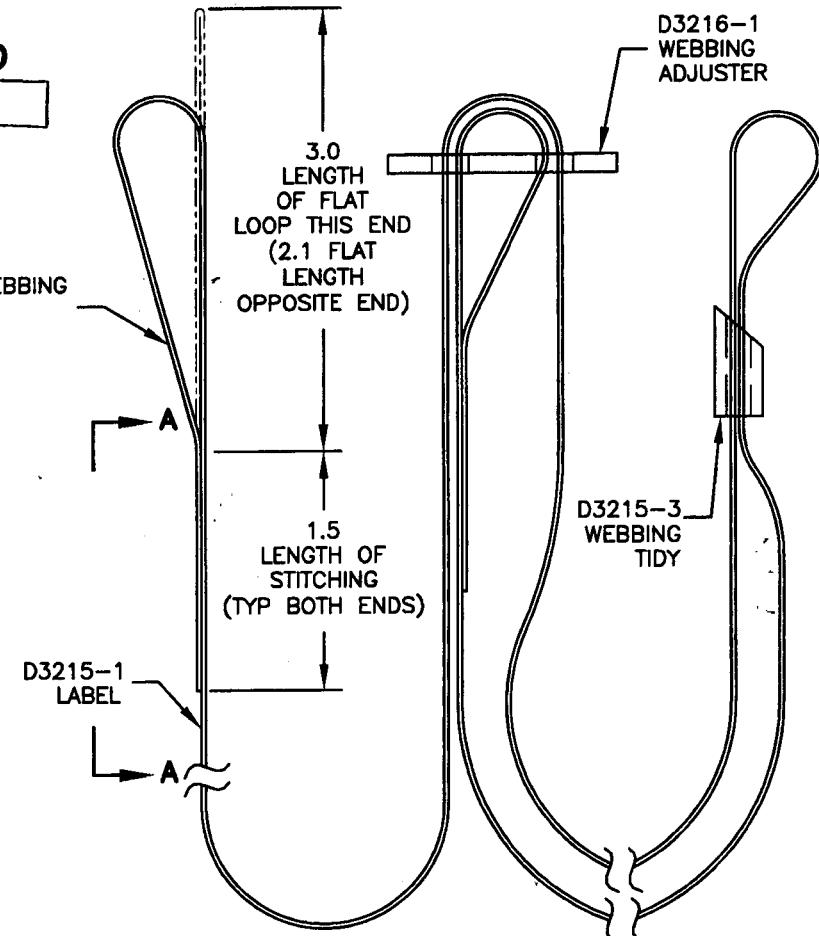
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3215
DATE 07.03.27		TITLE BELT ASSEMBLY
		SCALE NTS



ASSEMBLY DETAIL
NOT TO SCALE

RELEASED

07.06.07 *H*



D3215-041 BELT ASSEMBLY:

1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN

OR BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN

WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD

- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A

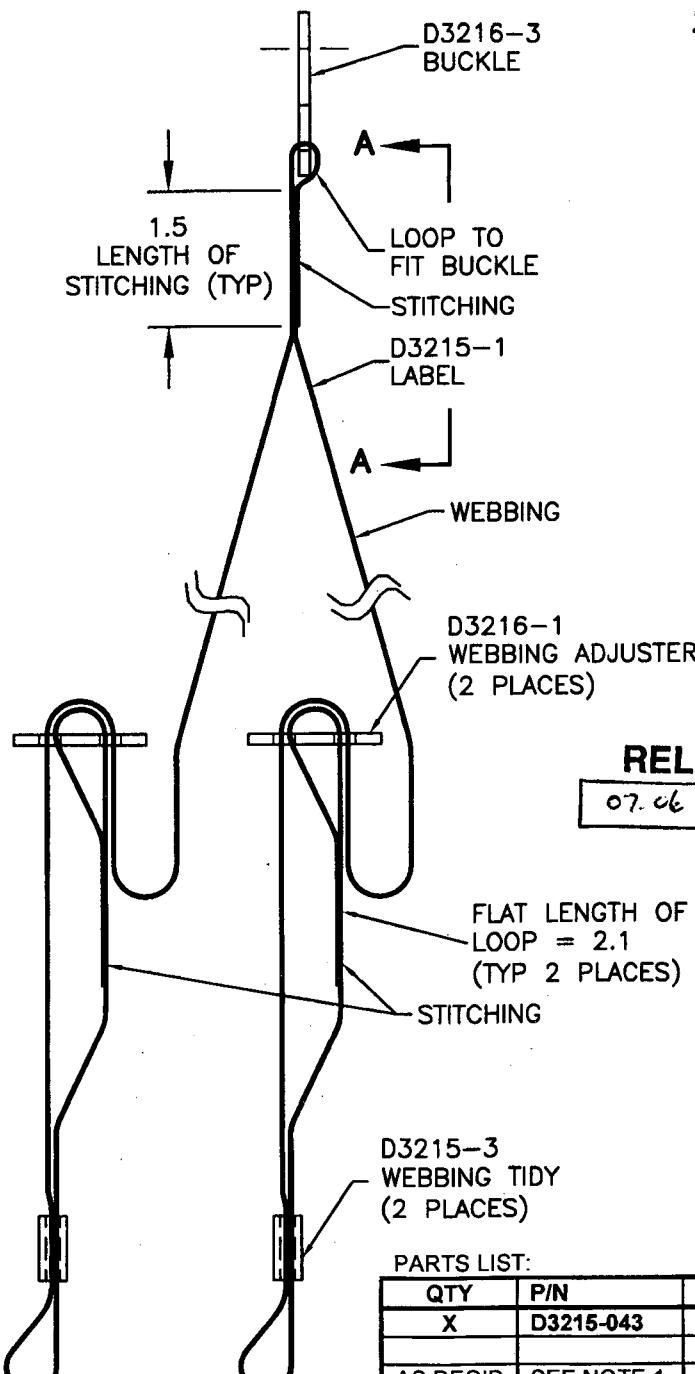
w/o 3/218

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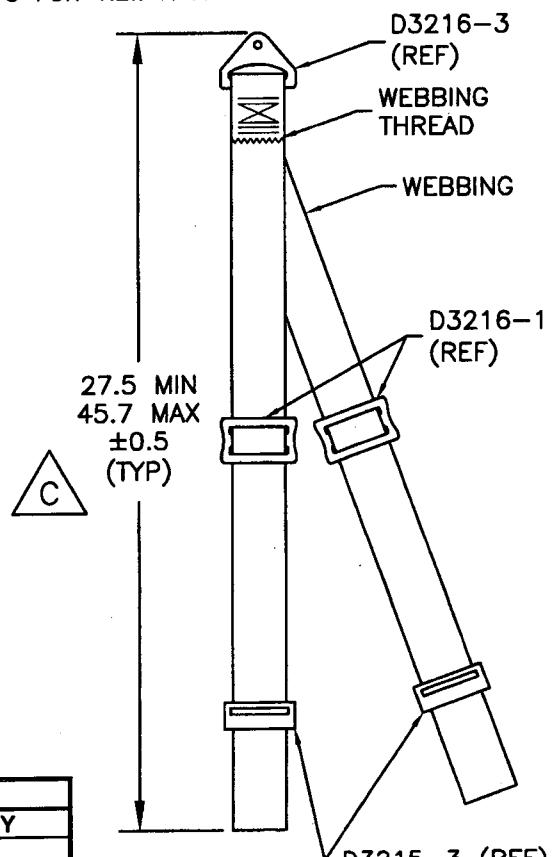
DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3215	REV. D SHEET 2 OF 3
DATE 07.03.27		TITLE BELT ASSEMBLY	SCALE NTS



D3215-043 BELT ASSEMBLY:

- 1) MATERIAL:
WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN
OR
BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A



ASSEMBLY DETAIL
NOT TO SCALE

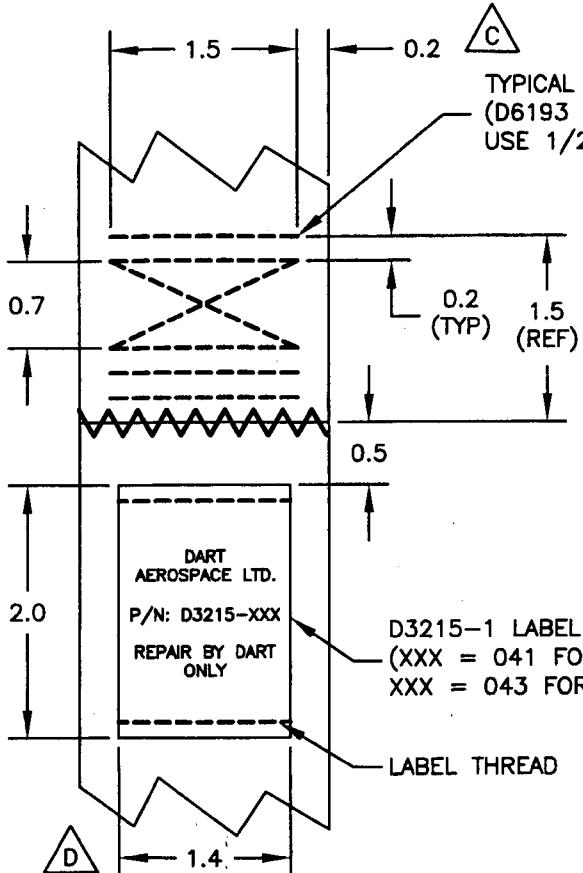
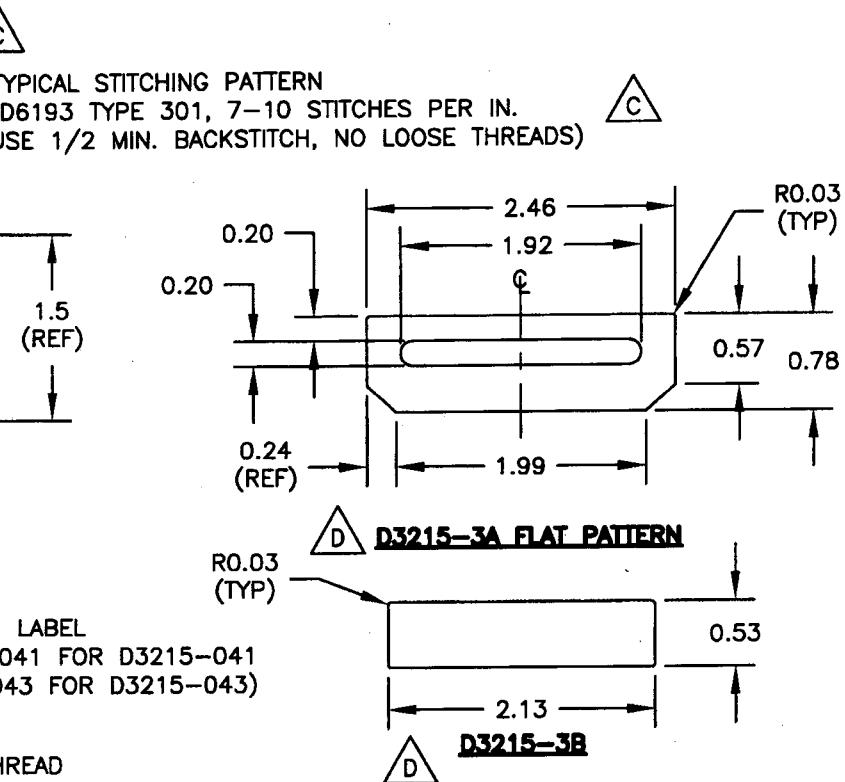
QTY	P/N	DESCRIPTION
X	D3215-043	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
2	D3215-3	WEBBING TIDY
2	D3216-1	WEBBING ADJUSTER

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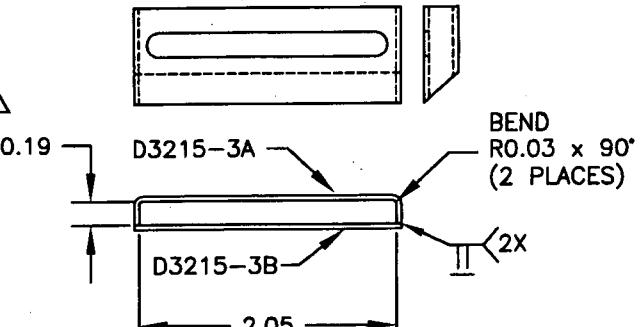
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DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>W</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27		TITLE HARNESS ASSEMBLY	SCALE 3:2

**VIEW A-A****D3215-3A/-3B NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7)
PER DART QSI 005 4.3

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DART AEROSPACE LTD	Work Order:	39718
Description: WEBBING TIDY	Part Number:	D3015-3
Inspection Dwg: D3215-3 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	KB	Audited by:	J	Prototype Approval:	✓ 7
Date:	8-6-5	Date:	08/06/05	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	